Date:

Tuesday, 01/05/2007 2:23:00 PM

User:

Linda Lacelle

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 31914

**Estimate Number** 

: 12707

P.O. Number This Issue

: NIA

: 01/05/2007

: NC

Prsht Rev. : NIA First Issue

Previous Run

Checked & Approved By

Comment

: 31914 Written By

: Est Rev : A New Issue 07-01-16

S.O. No. : NA

Type

: SMALL /MED FAB

**Part Number Drawing Number** 

**Drawing Name** 

**Project Number Drawing Revision** 

Material **Due Date**  : NA

: D35727

: N/A

: GUIDE ASS'Y

: D3572 REV.B

: 15/05/2007

Qty:

Each

**Additional Product** 

Job Number:



Seq. #:

Description:

6061-T6 .080 Sheet

M6061T6S080 1.0

Comment: Qty.:

0.0053 sf(s)/Unit Total:

0.6300 sf(s)

6061-T6 .080 Sheet Batch: M104186

FLOW WATER JET

2.0

WATER JET

**Comment: FLOW WATER JET** 

1-Cut as per Dwg D3572

Dwg Rev: 13 Prog Rev:\_\_

SAD 07/05/04

2-Remove tab only, do not deburr.

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

**PACKAGING 1** 

PACKAGING RESOURCE #1



5.0



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:



Page 1

Form: rprocess

Date:

Tuesday, 01/05/2007 2:23:01 PM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASS'Y

Job Number: 31914

Part Number: D35727

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



L07/05/08

Dart Aerospace Ltd. Tuesday, 4/17/2007 3:55:11 PM Kim Johnston User: **Process Sheet** : GUIDE ASS'Y : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 31914 : 12707 **Estimate Number** : D35727 **Part Number** P.O. Number D3572 UNDER REVIEW : 4/17/2007 S.O. No. : **Drawing Number** This Issue Project Number : N/A : NC Prsht Rev. : SMALL /MED FAB : U/R **Drawing Revision** : // First Issue Type : 31476 Material Previous Run Qty: 120 Um: Due Date : 5/12/2007 Written By Checked & Approved By : Est Rev : A New Issue 07-01-16 JLM Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: 6061-T6 .080 Sheet M6061T6S080 1.0 Comment: Qty.: Total 0.6300 sf(s)0.0053 sf(s)/Unit 6061-T6 .080 Sheet Batch: FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3572 Dwg Rev:\_ Prog Rev:\_\_\_ 2-Remove tab only, do not deburr. INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK PACKAGING RESOURCE #1 PACKAGING 1 5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

Each

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval QC inspector	
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Part No: _	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 07/5/08
			QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annecial
DATE STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
	:							
_								

NOTE: Date & initial all entries

Date: , Tuesday, 4/17/2007 3:55:12 PM ... Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASS'Y

Job Number: 31914

Part Number: D35727

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

EINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



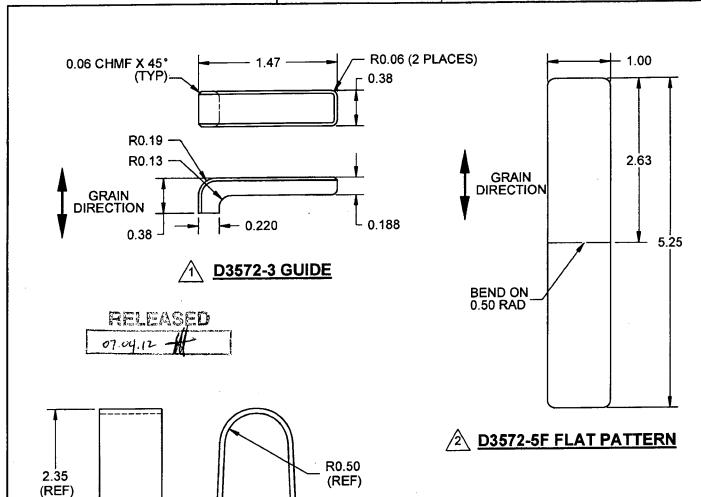
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DATE	STEP	Description of NC Section A	Initial	Corrective Action Se Action Description	ection B	Sign &		ation	Approval	Approval
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NOTE: Date & initial all entries

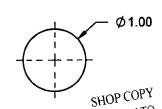
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D3572-3 GUIDE (4 PLACES)————————————————————————————————————	D3572-041	4X I GUIDE AS	D3572-1 TUBE  SSEMBLY  D3572-5 BRACKE	
D3572-041 NOTES:  1) PART IS SYMMETRIC ABOUT CENTI 2) FINISH: CHEMICAL CONVERSION C POWDER COAT GREY SANI 3) TOLERANCES ARE PER DART QSI 0 4) IDENTIFY WITH DART P/N "D3572-04 5) ALL DIMENSIONS ARE IN INCHES U 6) WELD PER DART QSI 004	OAT PER DART ( DTEX (4.3.5.6) PE	R DART QSI		
	26.75	· · · · · · · · · · · · · · · · · · ·		HOP COPY
D3572-1 NOTES: 1) MATERIAL: 6061-T6 (OR T62) ALUM	D3572-1	TUBE OD X 0.188	0.188 (REF) \	cupitro000 (REF)
(REF DART SPEC M606 2) TOLERANCES ARE PER DART QSI 0 3) ALL DIMENSIONS ARE IN INCHES UN 4) BREAK ALL SHARP EDGES 0.005 TO	ILESS OTHERWI		ED WIND.	WORK UNDER
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND	PYRIGHT © 2007 B	Y DART AERO EXPRESS CONDITION OUT WRITTEN PER	SPACE LTD ON THAT IT IS NOT TO BE USED FOR ANY PI MISSION FROM DART AEROSPACE LTD.	URPOSE OR COPIED



DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, C	
CHECKED	APPROVED	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.0	3.29	TITLE GUIDE ASSEMBLY	SCALE 2:3



D3572-5 BRACKET (MAKE FROM D3572-5F)



D3572-7 CAP GINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

**--** 1.16 <del>-></del>

<u>D3572-3/-5/-7 NOTES:</u>
1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)

2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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